

Date: Monday, 22/12/2008 3:06:06 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 44250	
Estimate Number : 12035	
P.O. Number :	Part Number : D33551
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3355 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30776	Material :
Written By :	Due Date : 20/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 08.12.23</u>	
Comment : est rev A 06.01.19 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR 1.250
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Comment: Qty.: 0.5250 f(s)/Unit Total : 3.1500 f(s)
AISI 4130N ROUND BAR 1.250"dia. batch: M110746

ML 09/02/07

(6 pcs)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 6.10" long

ML 09/02/07

(6 pcs)

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
1-Turn as per Dwg D3355

ML 09/02/07

(6 pcs)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1- Mill as per dwg D3355

2-Deburr as per dwg D3355

SP 09/02/09

(P/B)

(6)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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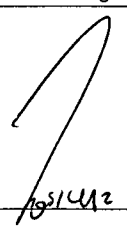
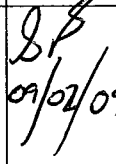
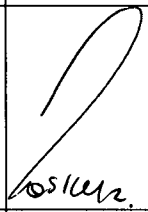
Comment: INSPECT WORK TO CURRENT STEP

8 09/02/09

(+5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3355-1 PAR #: NA Fault Category: Prod/Machined Yes NCR Yes No DQA: D Date: 09/02/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/02/11

NCR: 44250		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/2/9	4.1	one part found with 0.375" r.w. c' bore at 0.395" (0.020" over nominal) R.C. operator error / incorrect tool used to bore		Scrap and Destroy Qty (+1) no replace	 09/02/09	S 09/02/09		S 09/02/09

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 44250

Part Number: D33551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

SS 09/02/09 *ES*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/11 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

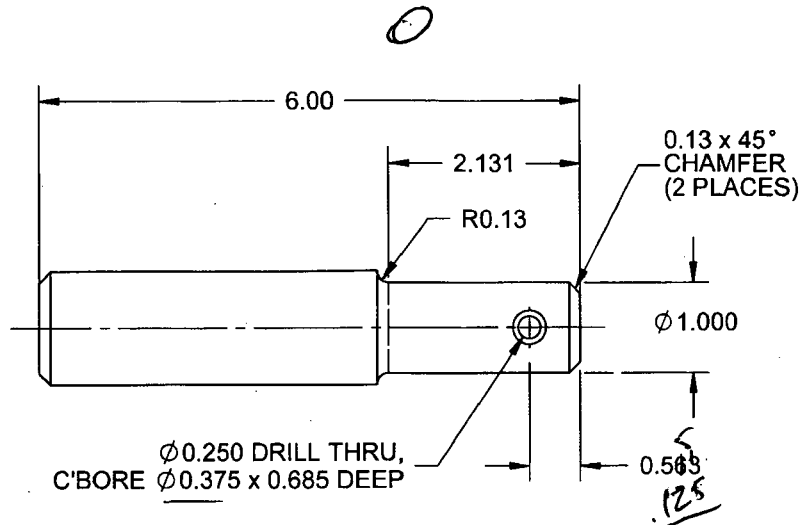
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

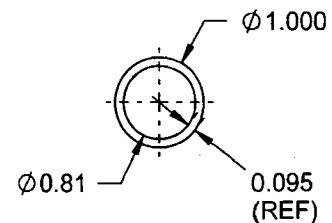
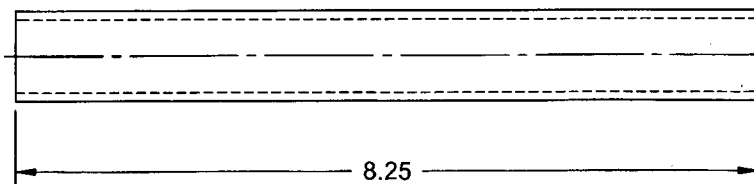
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 4 OF 6
DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:2

**D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44250

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